



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D119-646-314
Job Sheet 169166



Part No: D119-646-314

Job Qty: 1 ea

Part Name: Skidtube Protector, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/4/17

Job Tracking No:

Due Date: 12/15/17

Created By: Linda Lacelle

Type: SOLD

Description:

Customer: Agustawestland Philadelphia Corp (CAGUS02)

3050 Red Lion Road Philadelphia, PA, 19114 USA ph:(215) 281-1400 fx:(215) 281-0447.

Note: DWG REV B IPP REV:A 15.12.10 NEW ISSUE DD VERF:JLM IPP REV:B 17.05.10 AS PER DSI9734 REV B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/15/17	0.00	0.00	Start Up Stores/Pkg-1		SAL
110	Packaging	1 pcs		12/15/17	0.00	0.00	Packaging1-1		
120	QC	1 pcs		12/15/17	0.00	0.00	QC4		
125	DC	1 pcs		12/15/17	0.00	0.00	DC		
130	Packaging	1 pcs		12/15/17	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea		12/15/17	0.00	0.00	QC21		

Part Op 125 - Photocopy bluefile & type labels per PPP D119-646-313 CHG001
Descriptions: 130 - Identify and pack for shipping as per PPP D119-646-313 Location:

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	- AN3-45A 5018763	4 ✓	31	0	0
	- AN3-47A 5018756	6 ✓	22	0	0
	- AN3-50A 5018745	6 ✓	20	0	0
	- D3904-1 5018995	6 ✓	119	0	0
	- D4506-3 5018735	6 ✓	31	0	0
	- D5369-2 5018986	1 ✓	6	0	0
	- D5371-2 5018727	1 ✓	2	0	0
	- D5372-1 5018726	1 ✓	3	0	0
	- D5374-1 5018714	6 ✓	9	0	0
	- D5374-3 5018711	8 ✓	15	0	0
	- D5376-1	1 ✓	0	0	0
	- MS21042L3 5018704	10 ✓	4,687	0	0
	- NAS1149D0316J 5018702	4 ✓	961	0	0
	- NAS1149D0332J 5021088	18 ✓	1,679	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval _____
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Description Work Order Deviation	Disposition
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 S021094 Skidtube Protector, RH	Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	Completed By _____
		Lead hand / Supervisor Approval Verification _____
		QC / QA Coordinator Approval _____

PART NO: D119-646-314 Revision: Operation: Start up Operation Change No:	Mfg Date: 12/13/17 Job No: 169166	wer Loss/Surge ☐ lio/Program ☐ ain ☐ eld ☐ rong Stock Pulled ☐ t of Sequence ☐ ff-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
OTHER : _____			

REFERENCE ONLY

10.0 PARTS LIST:

Qty. -313	Qty. -314	PART NUMBER	DESCRIPTION
X		D119-646-313	SKIDTUBE PROTECTOR, LH
	X	D119-646-314	SKIDTUBE PROTECTOR, RH
6	6	D3904-1	WASHER
6	6	D4506-3	WASHER
1		D5369-1	CABLE GUARD, LH
	1	D5369-2	CABLE GUARD, RH
1		D5371-1	HOOK, LH
	1	D5371-2	HOOK, RH
1	1	D5372-1	PLUG
6	6	D5374-1	BUSHING
8	8	D5374-3	BUSHING
1	1	D5376-1	DRILLING JIG
4	4	AN3-45A	BOLT
6	6	AN3-47A	BOLT
6	6	AN3-50A	BOLT
18	18	NAS1149D0332J	WASHER
4	4	NAS1149D0316J	WASHER
10	10	MS21042L3	NUT

11.0 WEIGHT AND BALANCE

The following weight and balance changes are applicable:

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
D119-646-313 SKIDTUBE PROTECTOR, LH ON STANDARD SKIDTUBE	4.3 lb 1.95 kg	108.1 in 4.3 m	465 in-lb 8.4 kg-m	-43.4 in 1.7 m	-187 in-lb -3.3 kg-m
D119-646-314 SKIDTUBE PROTECTOR, RH ON STANDARD SKIDTUBE	4.3 lb 1.95 kg	108.1 in 4.30 m	465 in-lb 8.4 kg-m	43.4 in 1.7 m	187 in-lb 3.3 kg-m
D119-646-313 SKIDTUBE PROTECTOR, LH ON FLOAT SKIDTUBE	1.6 lb 0.72 kg	133.3 in 3.38 m	213 in-lb 2.4 kg-m	-43.4 in -1.7 in	69 in-lb 1.2 kg-in
D119-646-314 SKIDTUBE PROTECTOR, RH ON FLOAT SKIDTUBE	1.6 lb 0.72 kg	133.3 in 3.38 m	213 in-lb 2.4 kg-m	43.4 in 1.7 in	69 in-lb 1.2 kg-in



APPROVED

DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	VS		
CHECKED	MB	DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9734	SHEET 8 OF 15
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SKIDTUBE PROTECTOR KIT	NTS
DATE	17.06.27	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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Description: SKIDTUBE PROTECTOR, LH/RH

H:\Forms\Engineer\Approved Eng Online\CHGREC revB